

Soldering & Rework Station



Features:

- Advanced integrated computer provides outstanding thermo-control and thermo-stability for precise temperature control
- Dual LCD displays the working and parameter temperatures
- Quick-to-temp power up
- High flow diaphragm pump is suitable for a variety of nozzles to desolder SMD components
- Automatic shut-off and sleep mode for safety and energy savings
- Convenient buttons on the hand piece allow instant adjustment of temperature and air volume
- Memory stores up to three air and temperature presets

Apply

Industrial production
 Research department
 Maintenance industry
 Students
 Electronic assembly
 All enterprises and institutions

An intelligent, lead-free, and space-saving rework station which combines a rework station and soldering station. It is suitable for advanced hobbyists, repair, rework, and educational use. It is user friendly and a welcome addition to every work bench

Specifications

Model	21-10130	Intelligent lead-free rework station
Total power	About 900 W (maximum)	Heating : 800 (maximum) pump (diaphragh) : 40 W
Range for temperature controlling	Hot air rework station	100°C to 500°C
	Soldering station	200°C to 480°C
Temperature unit	°C/°F	Convertible
Temperature controlling stability	Static	2°C
Temperature controlling accuracy	Static	10°C
Calibration range	Celsius	-50°C to 50°C
	Fahrenheit	-58°F to 122°F
Setting storage (3 groups)	Rework station	1.2°C, 40 2.3°C 60 3.4°C 80
	Soldering station	1.2°C 2.3°C 3.4°C
Range of air volume	Rework station	020 - 100 level
Dormancy and standby	Rework station	Stopping heating, air-blowing delay and then be in the condition of dormancy
Cold air	Rework station	Air-blowing made by the machine
Malfunction alert	Heating elements	Displaying H-E
	Sensor	Displaying S-E
Shutdown	Shutdown in the normal condition	Cold air delay shutdown, power off

www.element14.com
www.farnell.com
www.newark.com
www.cpc.co.uk
www.mcmelectronics.com



Soldering & Rework Station



Specification for Soldering Iron:

Input voltage	: 220V AC / 110V AC
Power consumption	: 50W
Measurement	: 240mm × 40mm × 60mm
Gross weight	: 0.125Kg
Compatible for	: AT936B,21-10130 (AT8502D)

Safety and Caution

The temperature of the hot-air nozzle is 400°C so it may lead to injury, fire and other accident because of improper usage. Please abide the following terms:

1. Don't make the rework station be against people or animals. And never use it as a hair drier and touch the heating element or blow the skin directly
2. Never operate it near the flammable gas or substance and put it beside them after use
3. After use, the power should be off and it will be automatically off when the hot air temperature is lowered, (There is fuse inside, so great attention must be paid to superheat in case of accident)
4. Please care for using hot-air gun, never make it fall or shake heavily and put the heavy things on it or press the buttons improperly
5. Don't operate with wet hands or wet wire in order not to result in short circuit or electronic shock
6. Keep away from children
7. Please use the nozzle offered by manufacture and don't replace the original nozzle
8. Temperature will vary from the models of the nozzles, which is normal
9. Don't touch the iron tip or surrounding metals
10. Change the components or tip after cutting off power and waiting to cool it
11. Don't use this device do other work except soldering
12. Don't rap the handle to remove the doss of tip, which is bad for it
13. Don't pull the cable but hold tightly the plug when you take out of plug
14. Please keep good ventilation because there is smoke when solder
15. Don't play with other people or would be easy to hurt others or yourself

Characteristics

1. MCU computer offers PID advanced algorithms industrial control with thermo-control and thermo-stability, which makes more exactly control temperature
2. Dual LCD screen respectively and separately display the working state and parameter, which is very directly. So customer can understand the output state at a glance
3. Temperature rapidly rises with large output power
4. High flow diaphragm pump suitable for varies of nozzles to desolder SMD components
5. Dormancy, automatic shut down and other power-saving features
6. Shortcut keys on the handle make it more convenient for the user to adjust temperature and air volume
7. Three groups of storage functions can bring very fast mode of switching different groups of temperature and hot-air volume to the customers
8. All units are equipped with temperature compensation, which ensure stable state of operation
9. Indicator for malfunction alert

Soldering & Rework Station



Installation

The brackets for the handles must be installed when operating for the first time. Please see the following illustration:

1. Please fix the bracket by tightening the four screws according to the illustration and your personal habit
2. According to your selection, dismantle the two screws on the left or the right, which fix the bracket of the handle
3. Place the two installation hole of the bracket to the two fixed screw holes of the machine, and then tighten the dismantled two screws. Put the components of the handle on the bracket to check if it is suitable

Warning

This tool be placed on its stand when not in use. The instructions for heat guns and hand-held paint strippers shall include the substance of following: A fire may result if the appliance is not used with care, therefore be careful when using the appliance in places where there are combustible materials: Do not apply to the same place for a long time; Do not use in presence of an explosive atmosphere; Be aware that heat may be conducted to combustible materials that are out of sight ; Place the appliance on its stand after use and allow it to cool down before storage; Do not leave the appliance unattended when it is switched on.

Part Number Table

Description	Part Number
Soldering Iron, 60W, 220V/110V	AT907-936B
Soldering & Rework Station, ESD, UK+EU	21-10130 UK+EU

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Multicore 362 & 366

July 2007

ROSIN BASED CORED SOLDER WIRE FLUXES

Properties of Multicore 362 and 366 solid fluxes for cored solder wire:

- **Good wetting on most common surfaces**
- **Two activity levels: Multicore 362 for general work and Multicore 366 for more difficult surfaces**
- **Non-corrosive**
- **Fast soldering**
- **Rosin based**
- **Halide activated**

PRODUCT RANGE

Multicore 362 and 366 cored wires are manufactured with a range of flux contents. Although users will normally be using products with a nominal flux content of 3%. Multicore 362 and 366 cored wires are available in a variety of alloys conforming to J-STD-006 and EN 29453 or alloys conforming to similar national or international standards. For details refer to document "Properties of Alloys used in Cored Solder Wires". A wide range of wire diameters is available.

Alternative flux contents and alloys may be manufactured to special order.

TECHNICAL SPECIFICATION

A full description of test methods and detailed test results are available on request.

Alloys: The alloys used for Multicore flux cored solder wires conform to the purity requirements of the common national and international standards. A wide range of wire diameters is available manufactured to close dimensional tolerances. For details refer to document "Properties of Alloys used in Cored Solder Wires".

Flux: Multicore 362 and 366 solid flux leave dry and non-sticky residues. In use its odour is typically that of rosin fluxes.

TYPICAL FLUX PROPERTIES		
Test	362	366
Acid value	170mgKOH/g	158mgKOH/g
Halide content	<0.5%	1.0%
SIR Test (without cleaning) J-STD-004	Pass	Pass
Classification J-STD-004 EN29451-1	ROL1 1.1.2	ROM1 1.1.2

SPECIAL PROPERTIES

Surface Insulation Resistance: Multicore 362 and 366 flux pass the J-STD-004 SIR test and other elements of J-STD-004 test protocols associated with the flux classification ROL1 for 362 and ROM1 for 366.

Electromigration Test: Multicore 362 and 366 pass the Bellcore GR-78-CORE Electromigration test.

RECOMMENDED OPERATING CONDITIONS

Soldering iron: Good results should be obtained using a range of tip temperatures. However, the optimum tip temperature and heat capacity required for a hand soldering process is a function of both soldering iron design and the nature of the task and care should be exercised to avoid unnecessarily high tip temperatures for excessive times. A high tip temperature will increase any tendency to flux spitting and it may produce some residue darkening.

The soldering iron tip should be properly tinned and this may be achieved using Multicore cored wire. Severely contaminated soldering iron tips should first be cleaned and pre-tinned using Multicore Tip Tinner/Cleaner, then wiped on a clean, damp sponge before re-tinning with Multicore cored wire.

Soldering process: Multicore cored wires contain a careful balance of resins and activators to provide clear residues, maximum activity and high residue reliability, without cleaning in most situations. To achieve the best results from Multicore solder wires, recommended working practices for hand soldering should be observed as follows:

- Apply the soldering iron tip to the work surface, ensuring that it simultaneously contacts the base material and the component termination to heat both surfaces adequately. This process should only take a fraction of a second.
- Apply Multicore flux cored solder wire to a part of the joint surface away from the soldering iron and allow to flow sufficiently to form a sound joint fillet – this should be virtually instantaneous. Do not apply excessive solder or heat to the joint as this may result in dull, gritty fillets and excessive or darkened flux residues.
- Remove solder wire from the work piece and then remove the iron tip.

The total process will be very rapid, depending upon thermal mass, tip temperature and configuration and the solderability of the surfaces to be joined.

Multicore flux cored solder wires provide fast soldering on copper and brass surfaces as well as solder coated materials. Activity of the halide activated versions on nickel is also good depending on the state of oxidation of the nickel finish. The good thermal stability of Multicore fluxes means they are also well suited to soldering applications requiring high melting temperature alloys.

Cleaning: Multicore 362 and 366 cored solder wires have been formulated to leave pale flux residues and to resist spilling and fuming.

Cleaning will not be required in most situations but if necessary this is best achieved using Multicore MCF800 Cleaner (see separate technical data sheet). Other proprietary solvent or semi-aqueous processes may be suitable. Saponification may be viable but customers must ensure that the desired level of cleanliness can be achieved by their chosen system.

GENERAL INFORMATION

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Note

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ESD Black Coating Tweezers

DURATOOL

Feature:

- Made of anti-magnetic anti-acid stainless steel with ESDpolyester epoxy coating ($10^5 - 10^6 \Omega$)

D00830



Flat Round Tweezers (2A.SA ESD)
120 mm

D00831



Flat Round Tweezers (3.SA ESD)
120 mm

D00832



Sharp Tweezers (3C.SA ESD)
110 mm

D00833



Flat Round Tweezers (2A.SA ESD)
120 mm

D00834



Fine Curved Tweezers (7A.SA ESD)
115 mm

D00835



Straight Fine Tweezers (AA.SA ESD)
130 mm

DURATOOL

ESD Black Coating Tweezers



D00836



SMD Tweezers for handling and positioning 2 and 3 lead SOT (12.SA.SMD) 120 mm / 45° bent

D00837



SMD Tweezers for handling and positioning 1 mm components (13.SA SMD) 120 mm

D00838



Tweezers Kit with D00831,
D00832, D00834, D00836,
D00837
(3, 7A, 12SMD, 13SMD)

D00839



Tweezers Kit with D00831,
D00833, D00834, D00836,
D00837 (3, 5, 7A, 12SMD,
13SMD)

D00840



Tweezers Kit with D00831,
D00833, D00834, D00836,
D00837
(3, 3C, 5, 7A, 12SMD, 13SMD)



ESD Black Coating Tweezers



Part Number Table

Description	Part Number
Tweezers Type 2A SA ESD 120 MM	D00830
Tweezers Type 3 SA ESD 120 MM	D00831
Tweezers Type 3C SA ESD 110 MM	D00832
Tweezers Type 5 SA ESD 115 MM	D00833
Tweezers Type 7A SA ESD 115 MM	D00834
Tweezers Type AA SA ESD 130 MM	D00835
Tweezers Type 12 SMD SA ESD 120 MM	D00836
Tweezers Type 13 SMD SA ESD 120 MM	D00837
Tweezers Set, ESD Safe, 4PC	D00838
Tweezers Set, ESD Safe, 5PC	D00839
Tweezers Set, ESD Safe, 6PC	D00840

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Desoldering Pumps



8PK-366D-F



Features:

8PK-366D-F

- Rugged metal construction
- Anti-static tip
- Compact size

908-366A-F

- Anti-static desoldering
- Rugged metal construction
- Anti-static tip

908-366A-F



Part Number Table

Description	Part Number
Desoldering Gun	8PK-366D-F
Desoldering Gun	908-366A-F

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5" (125mm) Micro Cutter



DURATOOL

New

- An exceptionally clean smooth cut
- Lightweight and easy to handle
- Suitable for copper wire, not for use with steel wire
- Length: 5" (125mm)

Jaw Length 20mm Cutting Angle 23° Cutting Capacity 1.2mm
454577.427439.423850

Order Code	Price Each
115-6001	